



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

8727
D2932-1
Job Sheet 179293



Part No: D2932-1

Job Qty: 4 ea

Part Name: Saddle LH Out, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev, (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		6/29/18	0.00	0.00	Start Up Machining-1		SBL 18/07/27
100	CNC Vertical Machining	4 pcs		6/29/18	0.63	4.00	HAAS1-2		SBL 18/07/27
110	Mill Conv	4 pcs		6/29/18	0.00	0.67	Mill Conv 1		SBL 18/07/27
120	QC	4 pcs		6/29/18	0.00	0.00	QC1		SBL 18/07/27
130	QC	4 pcs		6/29/18	0.00	0.00	QC8 Machining-1		mmc 18/08/19
140	HandFinish	4 pcs		6/29/18	0.00	0.18	HandFinish1		DR 18-08-19
150	Powdercoat	4 pcs		6/29/18	0.00	0.20	Powdercoat1		AUG 2 0 2018 38
160	QC	4 pcs		6/29/18	0.00	0.00	QC3		9-89
170	Packaging	4 pcs		6/29/18	0.00	0.00	Packaging3-1	513966	AUG 2 3 2018
180	QC21-SA	4 Ea		6/29/18	0.00	0.00	QC21	9-8	21 AUG 2 4 2018

Part Op 100 - Program part number and batch number. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 &
Descriptions: attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per
110 - Machine Keyway and inspect per attached dimension sheet
120 - Inspect on CMM as per folio CMMA012.
150 - START TIME: _____ OVEN TEMPERATURE: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 Ea (1 ea)	90-Start up Operation	S011038 L-5096735

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-003	4	95	0

Part Specifications

Specifications could not be found.



Container No: S096738



Part: D2932-1

Job No: 179293

Serial No/Batch: S096738

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

DART Aerospace Ltd.
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Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/26/18

241
AC
09-1
BOS 0 1

DART AEROSPACE LTD	Work Order:	171273
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.128	.118	.118		
B	0.100	0.140		.120	.118	.117	.117		
C	0.100	0.140		.110	.118	.110	.110		
D	0.210	0.230		.226	.226	.224	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.500	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.239	.239		
N	0.100	0.140		.122	.122	.121	.122		
O	0.540	0.560		.550	.550	.551	.551		
P	0.490	0.510		.502	.503	.506	.501		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.470	2.510		2.492	2.490	2.490	2.490		
S	0.240	0.270		.255	.255	.255	.255		
T	0.100	0.180		.126	.130	.130	.128		
U	1.625	1.635		1.629	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585		1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	DAS 57
Date:	9-89 18/07/27

Audited by:	mmL
Date:	18/08/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DQA: _____ Date: _____

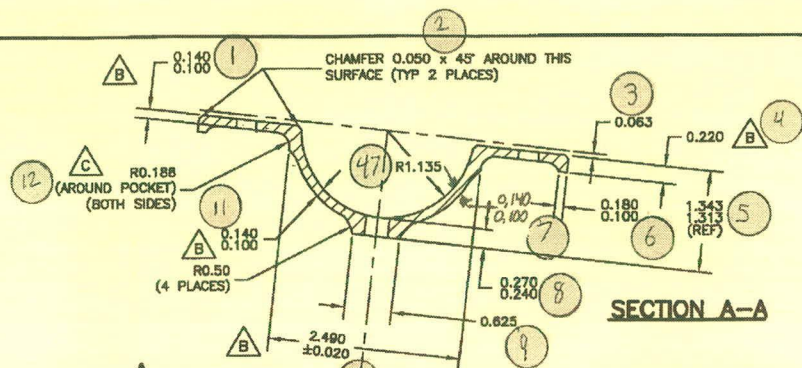


WORK ORDER NON-CONFORMANCE / UPDATE

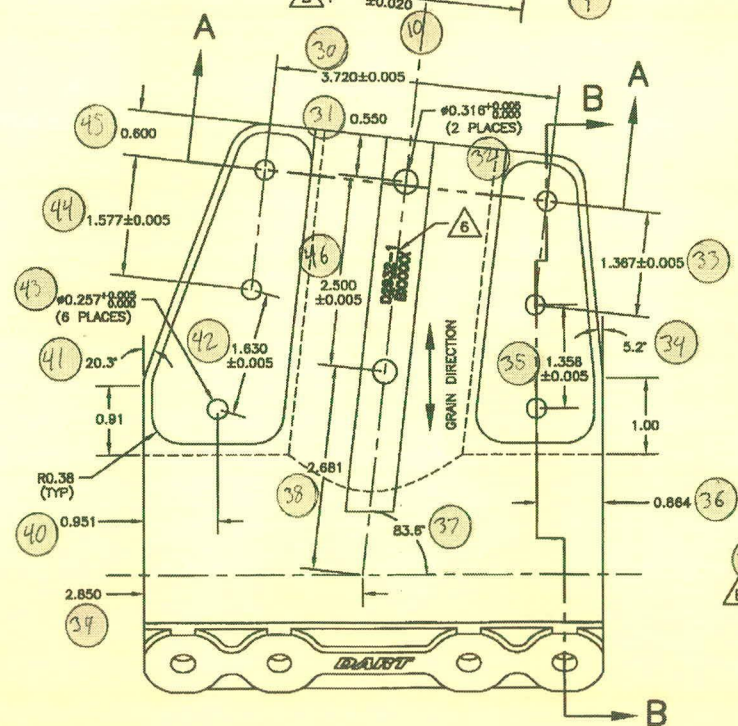
QA Closed: _____ Date: _____

Work Order update only ☐

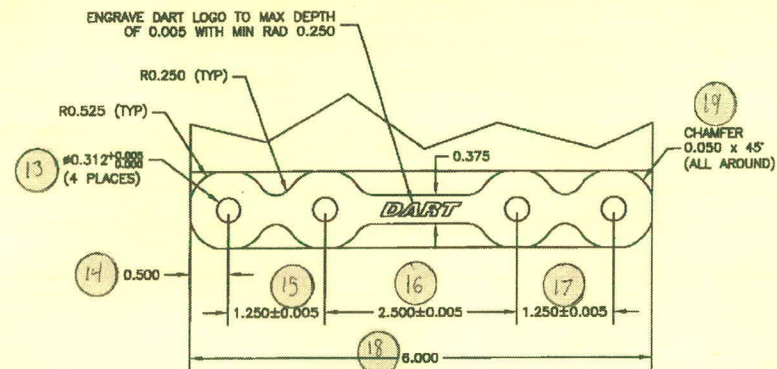
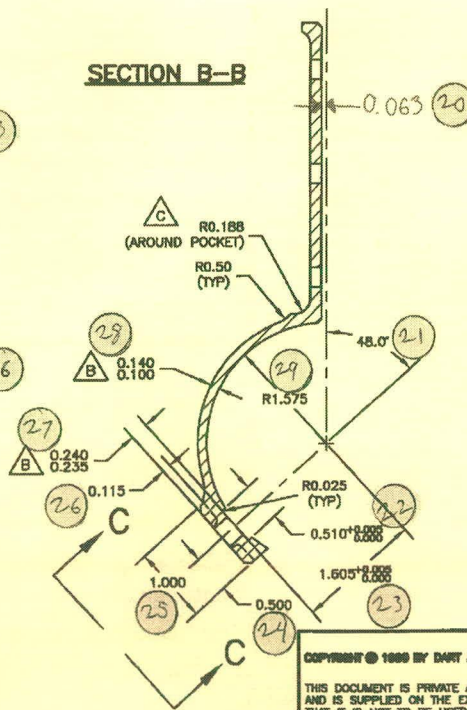
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
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OTHER : _____																					



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	PH	DRAWING NO. D2932
DATE	06.11.09	TITLE SADDLE OUTSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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DART AEROSPACE USA, INC.

RELEASED

07-02-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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